



Jobs/Hr	Spots/Job	Current(KA)	Cycles
60	11	18.0	10
Total			11

**80** % PHASE SHIFT (55 - 70)  
 - FOR "WESS" EQUIV. USE 80% AT MAX. CURRENT

ACTUAL TIP FORCE (lb)  
 STROKE (in)  
 CYLINDER BORE (in)  
 TRANSFORMER (in)  
 MIN. SHUNT AREA (in<sup>2</sup>)

GUN NUMBER  
 ENTER SKETCH NUMBER  
 STATION1

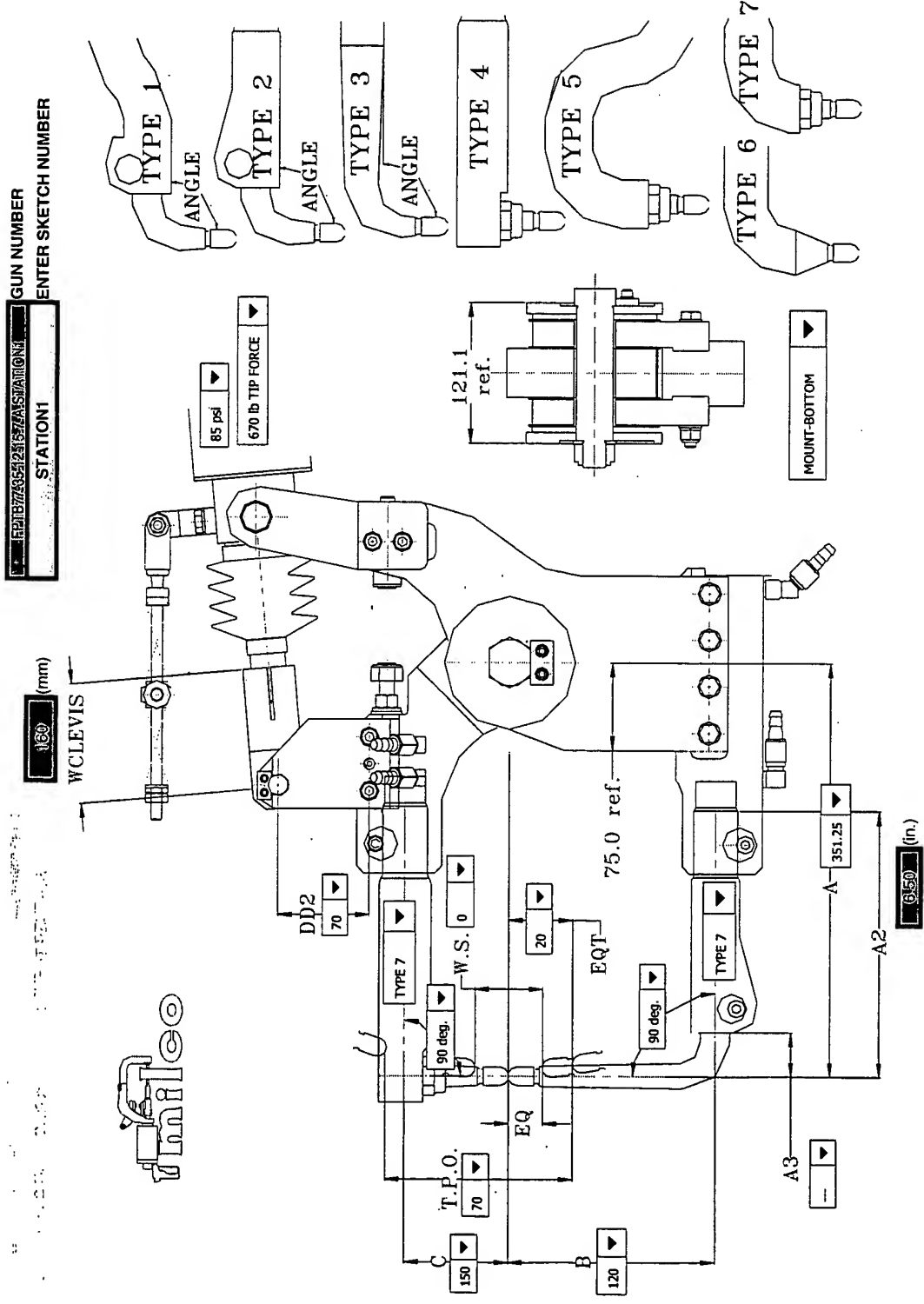


Figure 2

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<b>Jobs/Hr</b>	<b>Spots/Job</b>	<b>Current(KA)</b>	<b>Cycles</b>
80	10	10.5	9
Total	10		

**70** % PHASE SHIFT (55 - 70)  
- FOR "WESS" EQUIV. USE 80% AT MAX CURRE

691	ACTUAL TIP FORCE (lbf)
3150	BORE (in.)
2	RETRACT STROKE (in.)

55 KVA 63N ECR	TRANSFORMER
013	MIN. SHUNT AREA (in <sup>2</sup> )
242	GUN WEIGHT (lb)
101	C.G. FROM MOUNT X (mm)
73	C.G. FROM MOUNT Y (mm)

# NACHISF33 ROBOT

LINK ref.  (mm)

▶	EQUALIZATION
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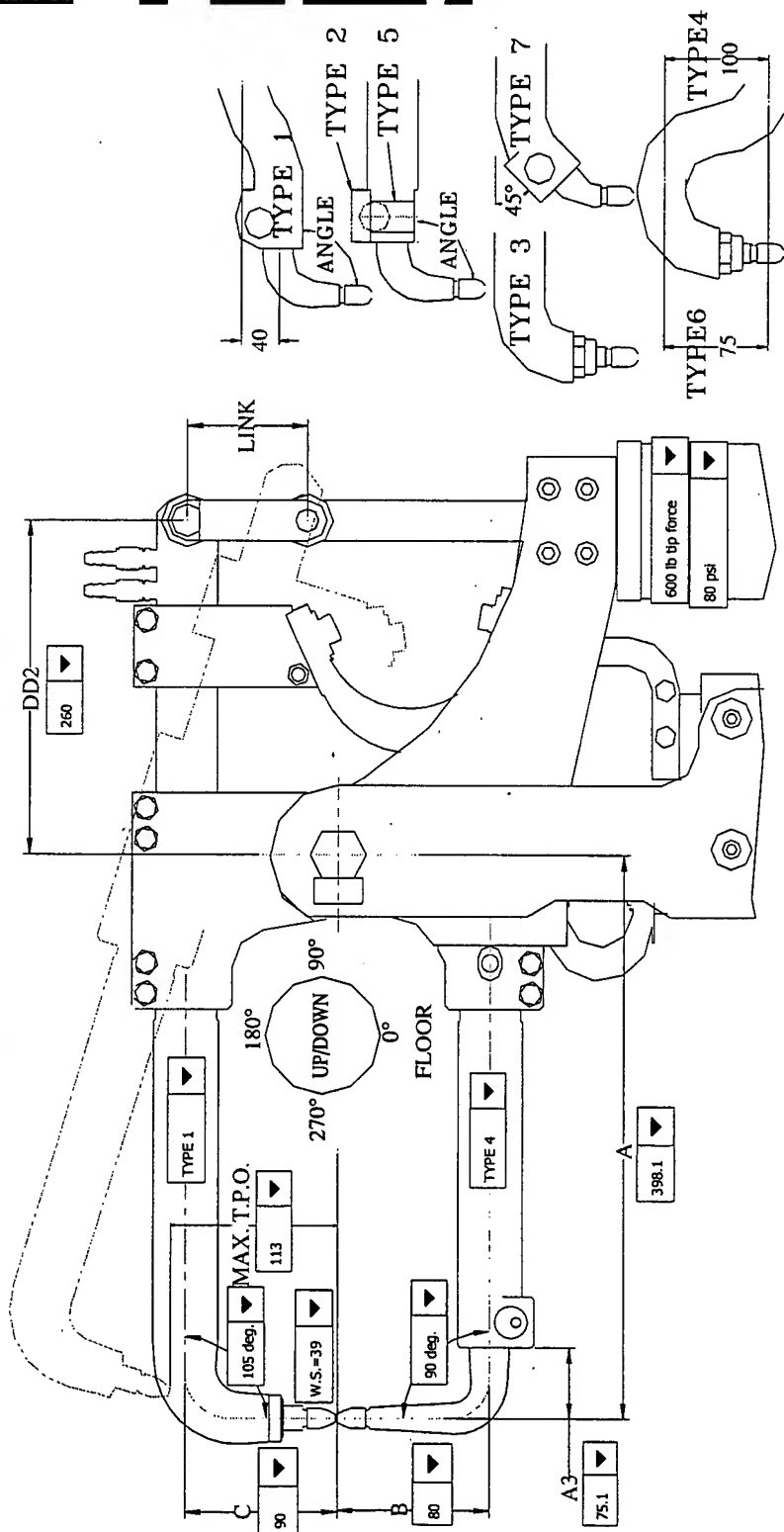
MILCO (DOX) MOUNT	▶
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MOUNT-RIGHT/LEFT/BO

PNEUMATIC	▶
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DCX SHANK 7/8"

5/8" CAPS	▶
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Floor1 -180 deg	▼
Floor2 -0 deg	▼

### Figure 3

GUN NUMBER  
 611-213-44ARS LINE3  
 ENTER SKETCH NUMBER  
 ARS LINE3

Jobs/Hr	Spots/Job	Current(KA)	Cycles
60	10	11.5	9
Total			10

70 % PHASE SHIFT (55 - 70)  
 - FOR "WESS" EQUIV. USE 80% AT MAX. CURRENT

ACTUAL TIP FORCE (lb) 760  
 STROKE (in) 2.80  
 CYLINDER BORE (in) 2.50  
 TRANSFORMER 65 KVA 63V  
 MIN. SHUNT AREA (in²) 0.2  
 SKID (in) 0.500

WELD TO CYLINDER 14.3 (in)

GUN WEIGHT (lb) 210  
 C.G. TO MT X (mm) 143  
 C.G. TO MT Y (mm) 177  
 ROBOT NACHI S700

DCX SHANK 1.24" ▼  
 MOUNT-BOTTOM ▼  
 PNEUMATIC ▼  
 5/8" CAPS ▼

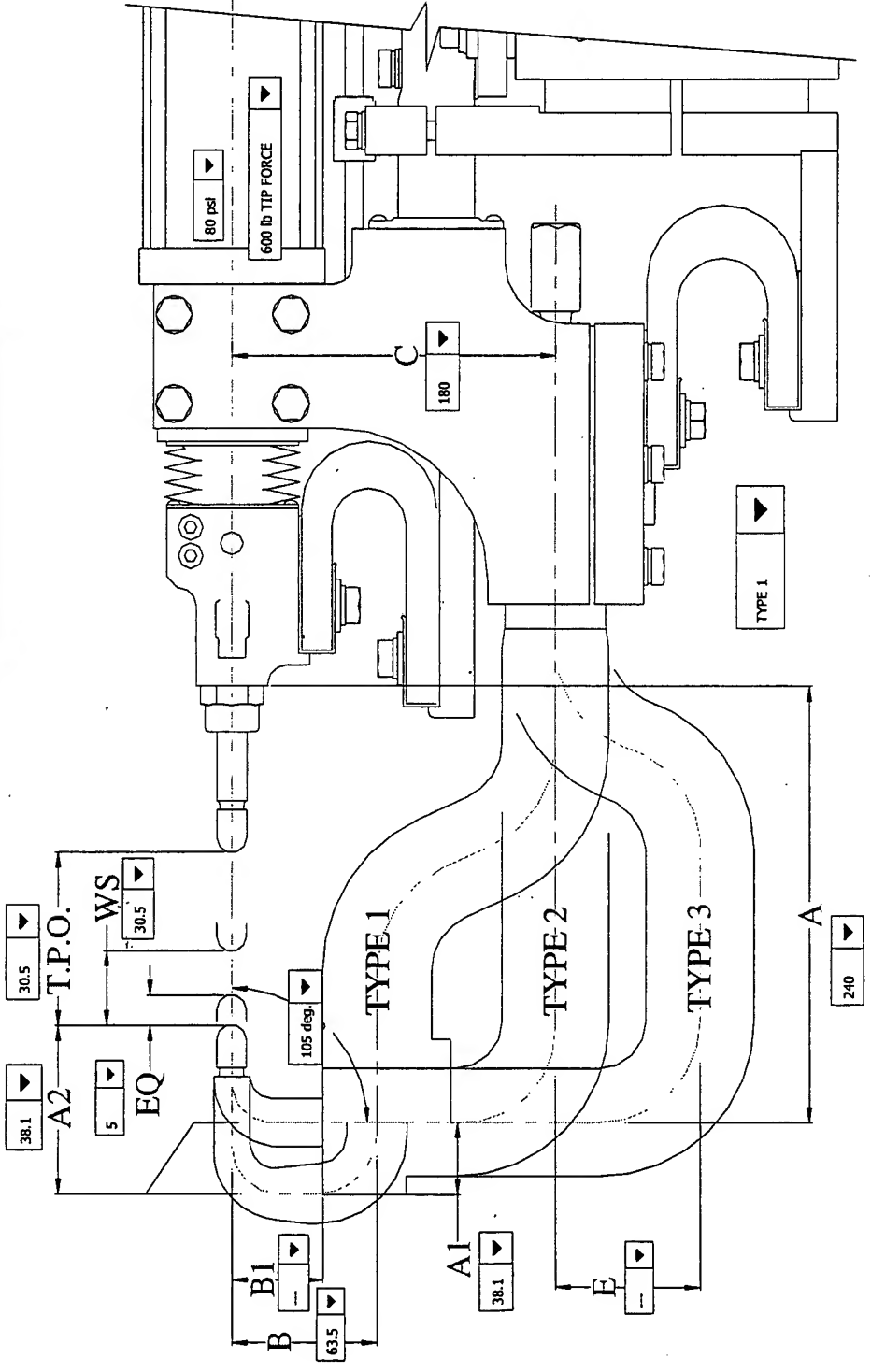
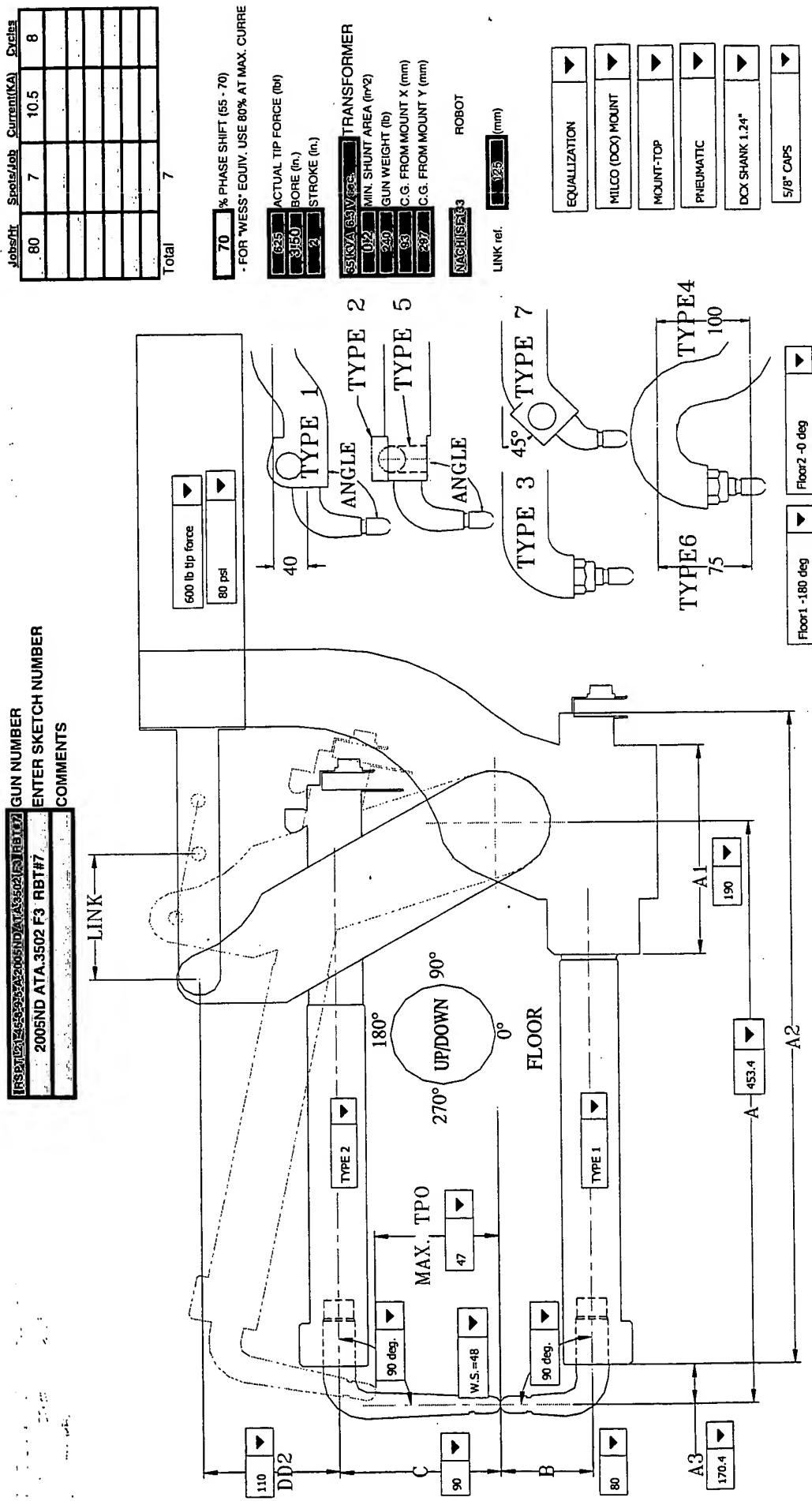
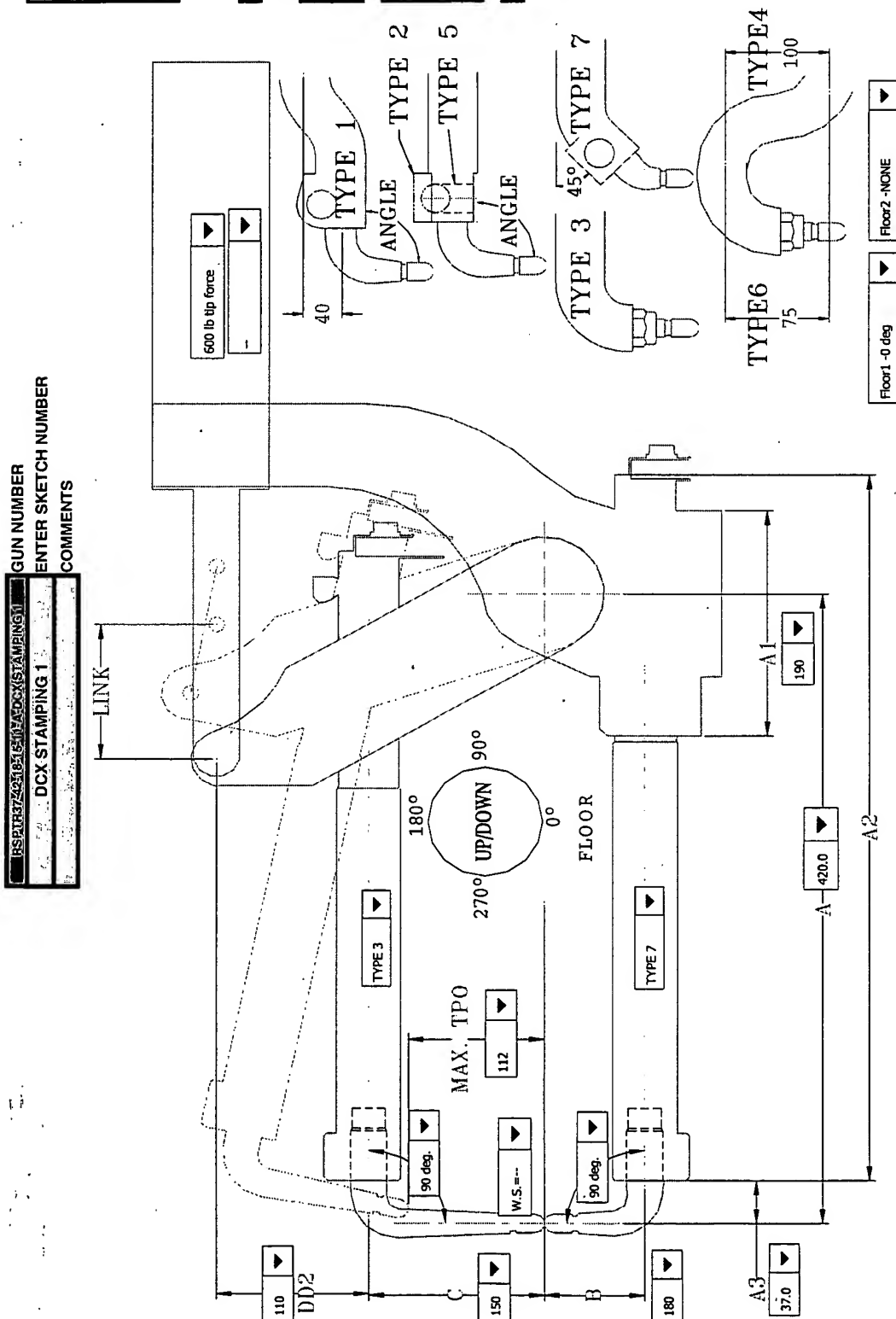


Figure 4



NO EQUALIZATION	▼
MILCO (DCX) MOUNT	▼
MOUNT-RIGHT/LEFT/BC	▼
SERVO	▼
DCX SHANK 1.24"	▼
3/4" CAPS	▼



## Figure 6

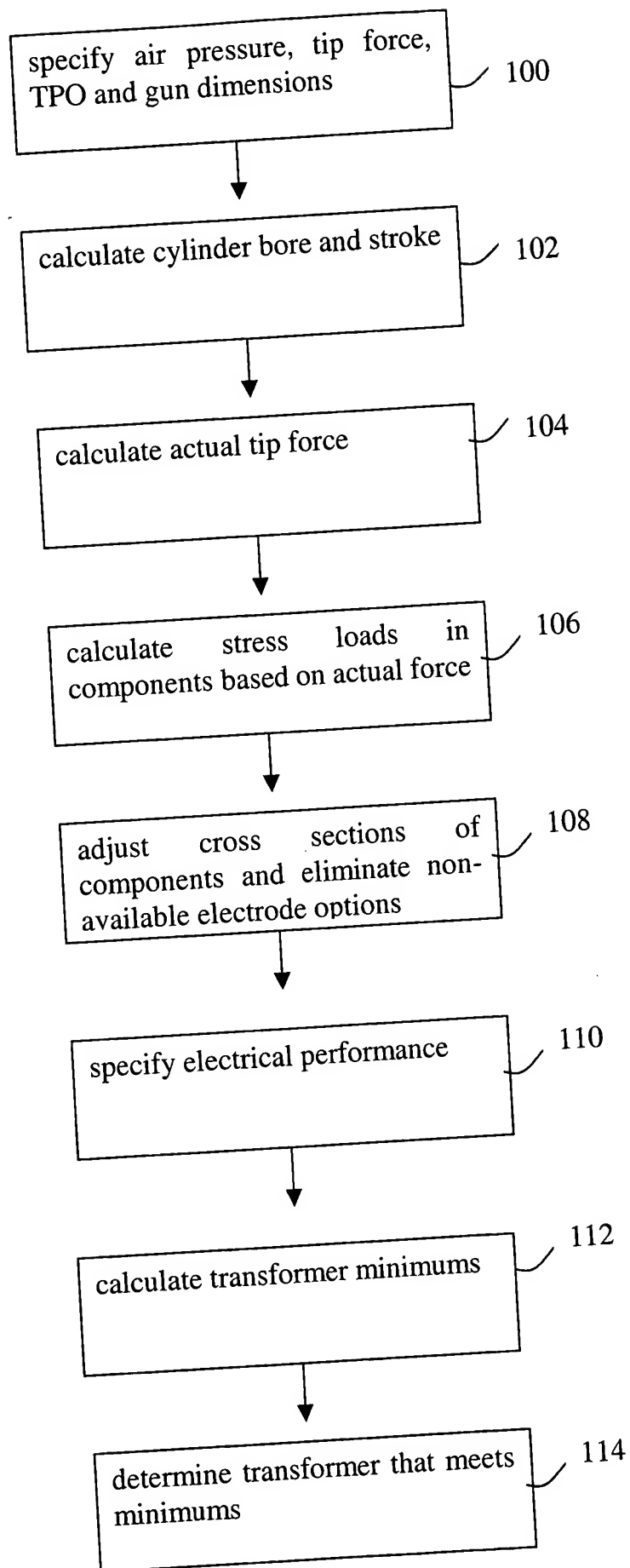


Figure 7